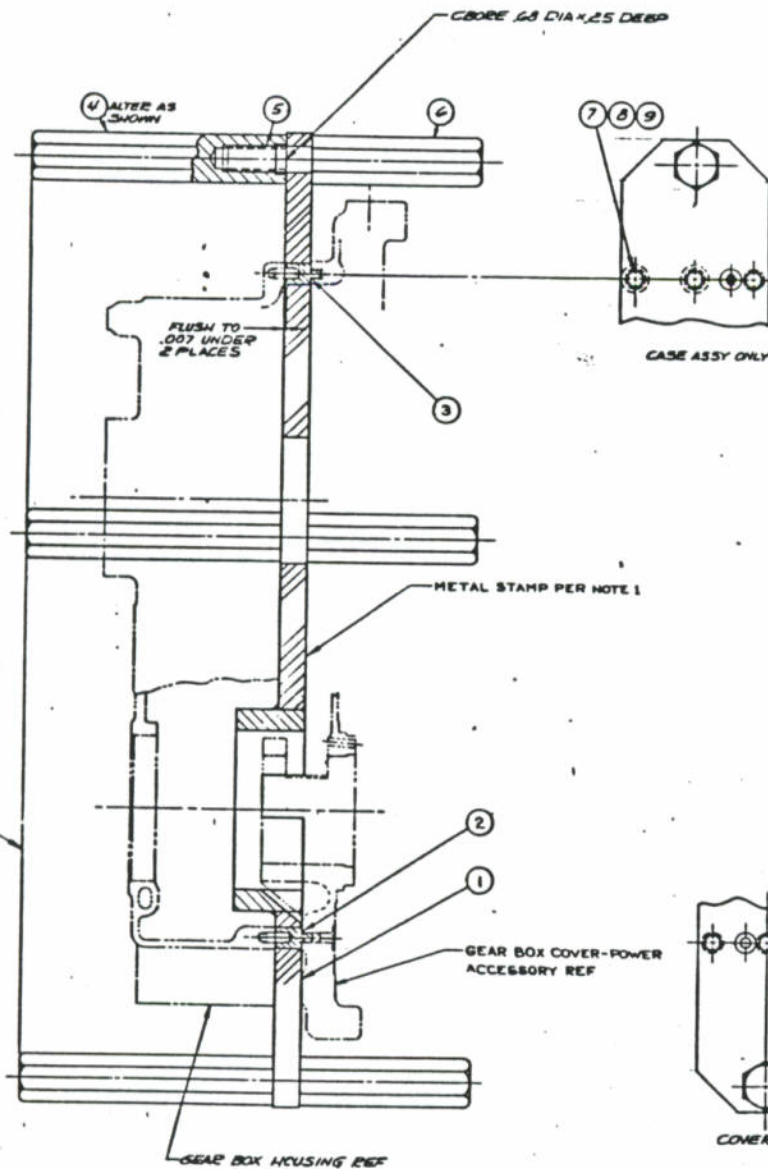


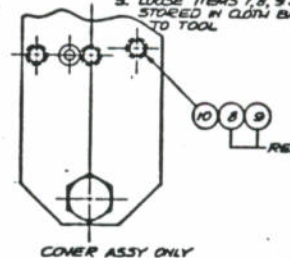
REV	DATE	BY	CHKD	APP'D
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1. MARK AS SPECIFIED IN LOCATION SHOWN WITH 4-8-3/16 HIGH FIGURES THE FOLLOWING: AT THE NAME "ALLISON" FOLLOWED BY THE TOOL NUMBER AND LAST CHANGE LETTER. AT VENDOR NAME OR TRADENAME.
2. BLACK OXIDE PER AMS 2485 ITEM 1, 2 & 3.
3. LOOSE ITEMS 7, 8, 9 & 10 TO BE STORED IN CLOTH BAG & ATTACHED TO TOOL.



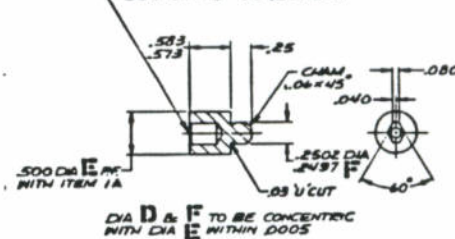
REDUCED PRINT

BREAK SHARP EDGES .020 UGOS

USED ON ENGINE MODELS
250 SERIES

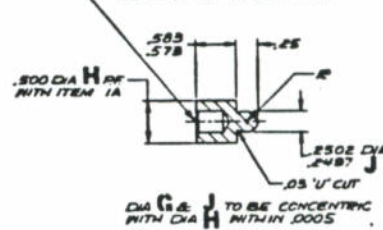
DETROIT DIESEL, ALLISON DIVISION RESEARCH, DEVELOPMENT, PRODUCTION DETROIT, MICHIGAN 48216-1000	AMS 2485 BLACK OXIDE
WU TEMPLATE-INDICATING, GEAR-BOX COVER AND HOUSING GEARING BORE	8872758
DATE: 10/1/88 BY: 73342 CHKD: 73342	8872758

2512-2522 DIA D .512 DEEP
CSK 90° TO .251 DIA



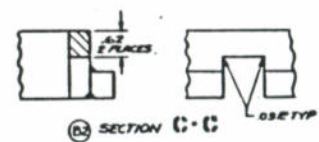
3 SAE 4140 HON RC 34-40 AND GRIND
SCALE: 2/1

2512-2522 DIA G .512 DEEP
CSK 90° TO .251 DIA



2 SAE 4140 HON RC 34-40 AND GRIND
SCALE: 2/1

SHOP COPY



**REDUCED
PRINT**

BREAK SHARP EDGES 0.02003		TEMPLATE-INDICATING SPAD BOX COVER AND HOUSING BEARINGS BORE	
DATE: 11/1/54	BY: J. J. J.	DATE: 11/1/54	BY: J. J. J.
NOTED	NOTED	NOTED	NOTED
6872758		6872758	

.654-.665 DIA DRILL THRU
4 HOLES LOCATED WITHIN
.014R OF TP

.375-1/4 TAP X .75 DEEP

.500 DIA PRESS FIT WITH ITEM 3
LOCATED WITHIN .0005R OF TP

.217-.225 DIA DRILL THRU
C BORE .68 DIA X .38 DEEP
2 HOLES LOCATED WITHIN
.007 R OF TP

.217-.225 DIA DRILL THRU
THRU 4 LOCATED
WITHIN .007 R OF TP

.217-.225 DIA DRILL THRU
C BORE .68 DIA X .38 DEEP (OPPOSITE SIDE)
6 HOLES LOCATED WITHIN
.007 R OF TP

.217-.225 DIA DRILL THRU
5 HOLES LOCATED
WITHIN .007 R OF TP

.500 DIA PRESS FIT WITH ITEM 2
LOCATED WITHIN .0005R OF TP

CHAM 1.00 X .45
8 PLACES

WELDMENT-NORMALIZE AFTER FELD
SAE 4130 HON RC 34-40

DIA B & C SHALL BE LOCATED
WITHIN .0005R OF TP

SECTION B-B

SECTION A-A